

Date: Thursday, 3/23/2006 3:52:09 PM
 User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: 206 L WEB
Job Number	: 26365		
Estimate Number	: 10722		
P.O. Number	: N/A	Part Number	: D26547
This Issue	: 3/23/2006 S.O. No. : N/A	Drawing Number	: D2654 REV E1
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: 3/23/2006 Type : LANDING GEAR	Drawing Revision	: E1
Previous Run	: 25107	Material	: N/A
Written By	: <u>See comment below</u>	Due Date	: 3/30/2006
Checked & Approved By	: <u>Rf 06.03.24</u>	Qty:	3 Um: Each
Comment	: Est Rev:D 99.02.04 Fixed typo, Changed procedure DM		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	D26007125	Extrusion 'I Beam' thick
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 3.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
1	D2600-7- 125	Web	B 21130 (3) IT 06-03-30

2.0	LANDING GEAR 1	LANDING GEAR RESOURCE 1
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Comment: LANDING GEAR RESOURCE 1

1-Cut D2600-7 to length as per Dwg D2654 IT 06-03-30 (3)

2-Drill pilot holes in web using drill jig DT 8018-7 as per Dwg D2654 IT 06-03-30 (3)

3-Using the uni-bit, open holes to finish size as per Dwg D2654 IT 06-03-30 (3)

4-Deburr holes and ends IT 06-03-30 (3)

3.0	QC5	INSPECT WORK TO CURRENT STEP
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Comment: INSPECT WORK TO CURRENT STEP

BE ~~IT~~ 06-04-03 (3)

4.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
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Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

IT 06-04-01 (3)

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: DP Date: 06/04/04
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action		Section B		Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date				
06-04-03	2	.750 hole (105.00" location) was drilled at at the opposite end. Human error Human error	<u>DP</u>	holes are acceptable. Drill fuel holes .750 as per Dwg.	<u>DP</u>	06-04-03	<u>2</u>	<u>DP</u>	<u>2</u>

NOTE: Date & initial all entries

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Drawing Name: 206 L WEB

Job Number: 26365

Part Number: D26547

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

BE 06-04-03 (43)

6.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: LG

IT 06-04-01 (3)

Job Completion



Inspection Level 21 RD 06/04/04

U Study

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action		Section B		Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date				

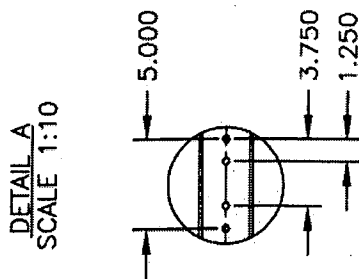
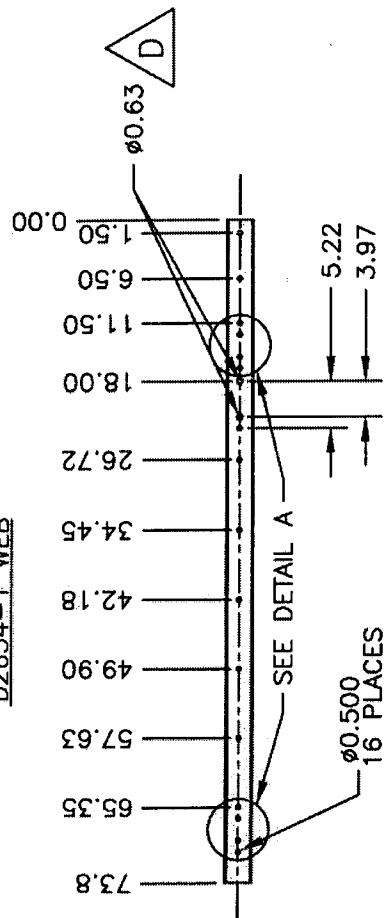
NOTE: Date & initial all entries



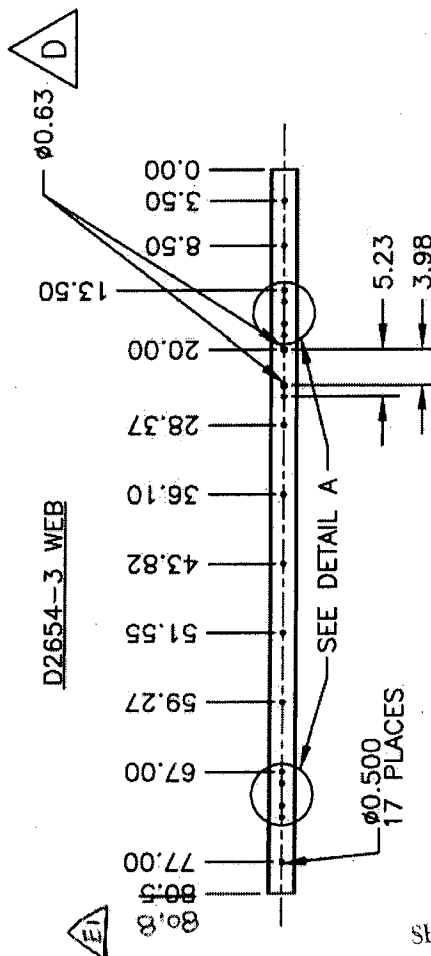
DESIGN	CP	DRAWN BY	CP	DART AEROSPACE USA, INC.
				PORT HADLOCK, WA
CHECKED	#	APPROVED	#	DRAWING NO. D2654
				REV. E
				SHEET 1 OF 2
DATE	04.05.26	TITLE	WEB	SCALE 1:20
A	97.03.25	NEW ISSUE		
B	97.06.26	ALTER HOLE PATRN., 0.500 WAS 0.438		
C	97.10.29	CHANGED HOLE PATTERN		
D	98.01.15	GHW HOLES CHANGED TO $\phi 0.63$		
E	04.05.26	CHANGE LENGTHS, REFORMAT		
E1	CP 04.08.04	PER TOOLING; 80.8 WAS 80.5		

RELEASED
04.06.22

D2654-1 WEB



D2654-3 WEB

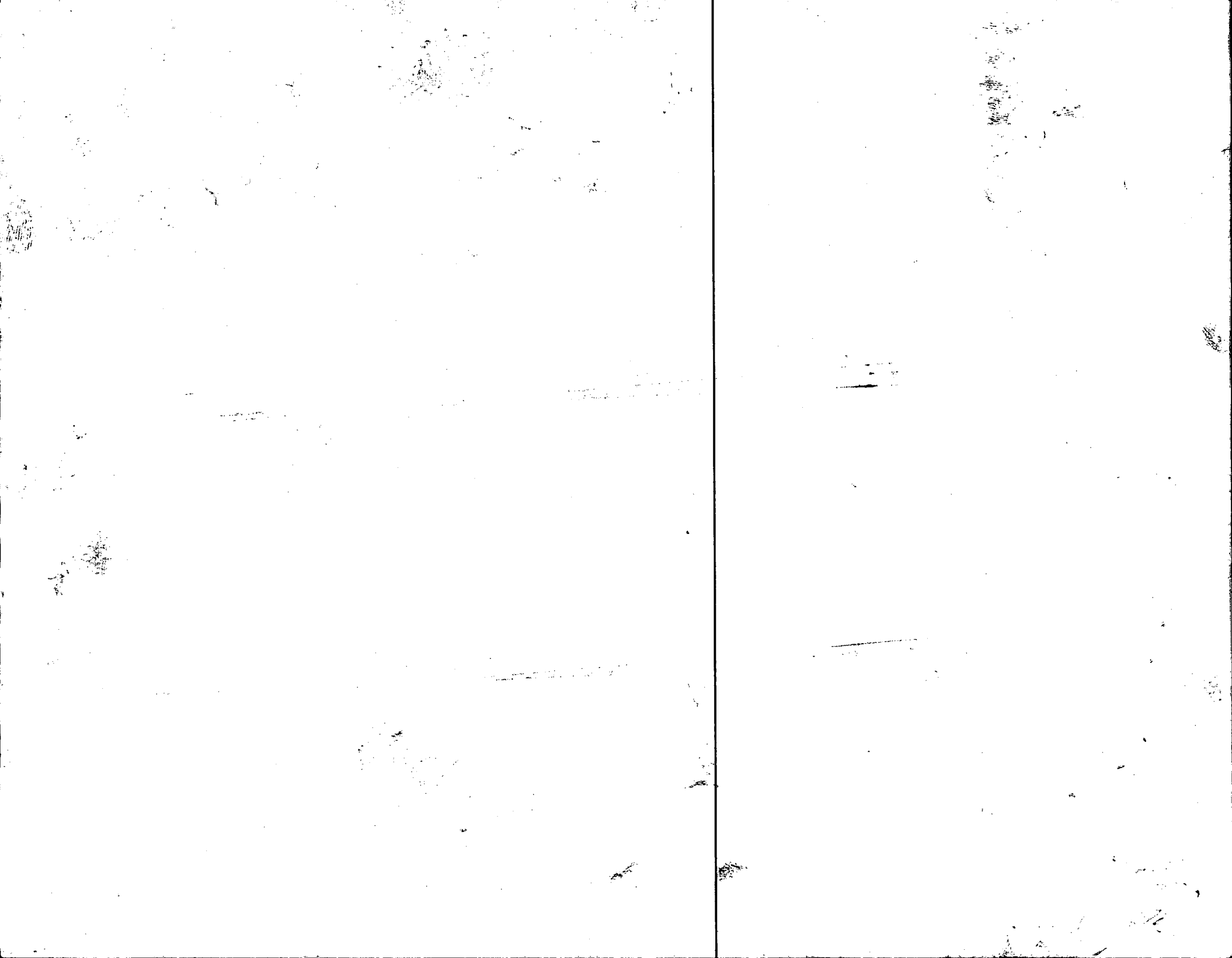


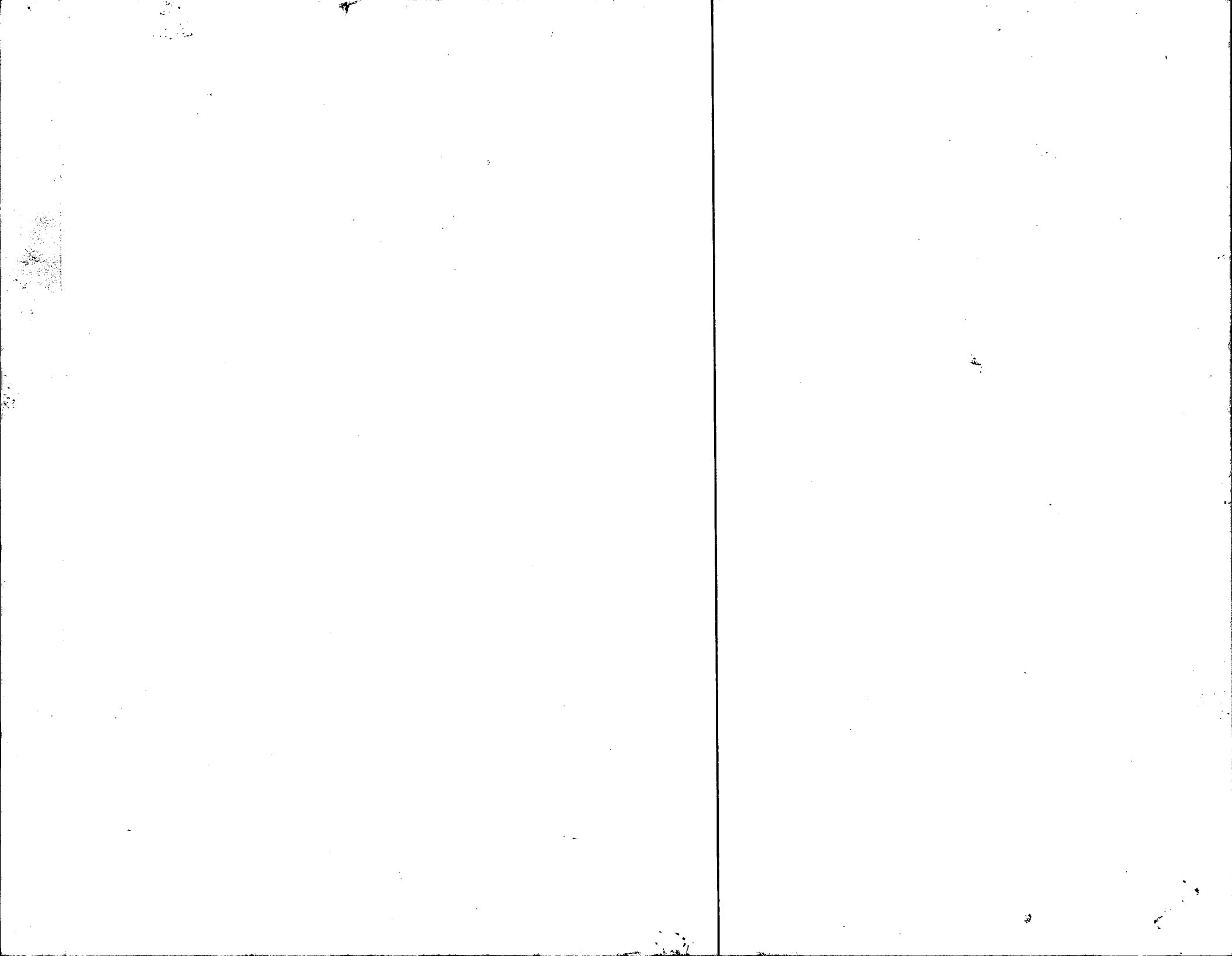
SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 26365

MAKE FROM D2600-5-108 EXTRUSION
FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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Linda Lacelle

From: David Shepherd [davids@dartaero.com]
Sent: Monday, April 03, 2006 11:36 AM
To: Chris Provencal
Cc: Linda Lacelle; Jason Murdoch
Subject: Fw: NCR for D2654-7



206L_web_problem
.jpg

Chris,

This is an acceptable deviation.

David

----- Original Message -----

From: "Chris Provencal" <cprovencal@dartaero.com>
To: <davids@dartaero.com>
Sent: Monday, April 03, 2006 8:02 AM
Subject: NCR for D2654-7

> Dave,
>
> D2654-7 Web for the 206L. They opened the hole for the tarring on the
wrong
> end by mistake, so both ends will have a 0.75" dia hole now. Qty(3) are
> affected by this. I see no problem with this myself.
>
> Sincerely,
> Chris Provencal
> DART Aerospace Ltd.
> Email..cprovencal@dartaero.com
> Phone...613-632-3336
> Fax.....613-632-4443
>
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